

Date: Friday, 30/05/2008 10:12:34 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROTECTOR RH
Job Number	: 39596		
Estimate Number	: 11225		
P.O. Number	:	Part Number	: D32803
This Issue	: 30/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3280 REV.D
First Issue	: / /	Project Number	: N/A
Previous Run	: 37782	Drawing Revision	: D
Written By	:	Material	:
Checked & Approved By	: <u>JUL 08.5.30</u>	Due Date	: 10/06/2008
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM : Est RevB 07.09.12 Thermoform in house DL : Est Rev C 08.03.11 Dwg. Rev Change. DL : Est Rev D 08.04.15 Material Change DL		

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
-----	-----------------	-------------------------



Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s)
 GE PLASTICS LEXAN SHEET

Material Batch Number

M 106751

BB 08/02/06

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



PH

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/02/06 X10 (10)

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 012

Dwg. Rev.

D

Folio Rev.

3C

BB 08/02/06 X10 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



BB 08/02/06 X10 (10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3280-3 PAR #: U/A Fault Category: Prod / Thermal Family NCR: Yes No DQA: D Date: 08/06/09
 QA: N/C Closed: D Date: 08/06/09

NCR: 39596		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/09	#20	one Part Part scrap sheet overheated. RL oven stuck over the Part.	<i>[Signature]</i>	Scrap and destroy no replace qty @	<i>[Signature]</i> 08/06/09	<i>[Signature]</i> 08/06/09	<i>[Signature]</i>	<i>[Signature]</i> 08/06/09

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:34 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR RH

Job Number: 39596

Part Number: D32803

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB

08/06/03

49

6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB

08/06/03

49

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5 08/06/05 49

8.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

8/6/5

9x

9.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

08/06/09

Job Completion



MF 08-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39596
Description: R22 Floor Protector, RH		Part Number: D3280-3
Inspection Dwg: D3280	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

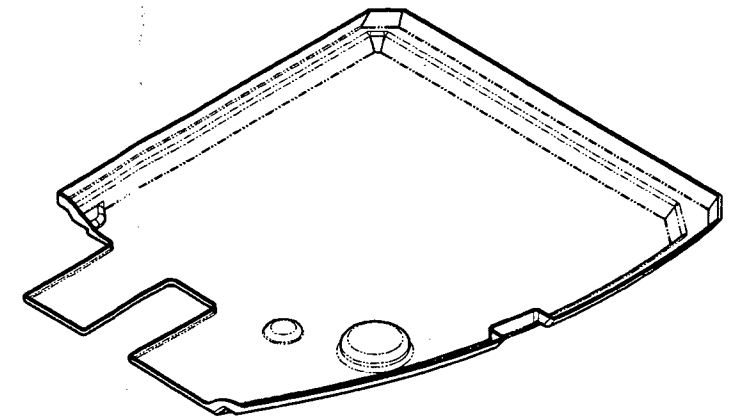
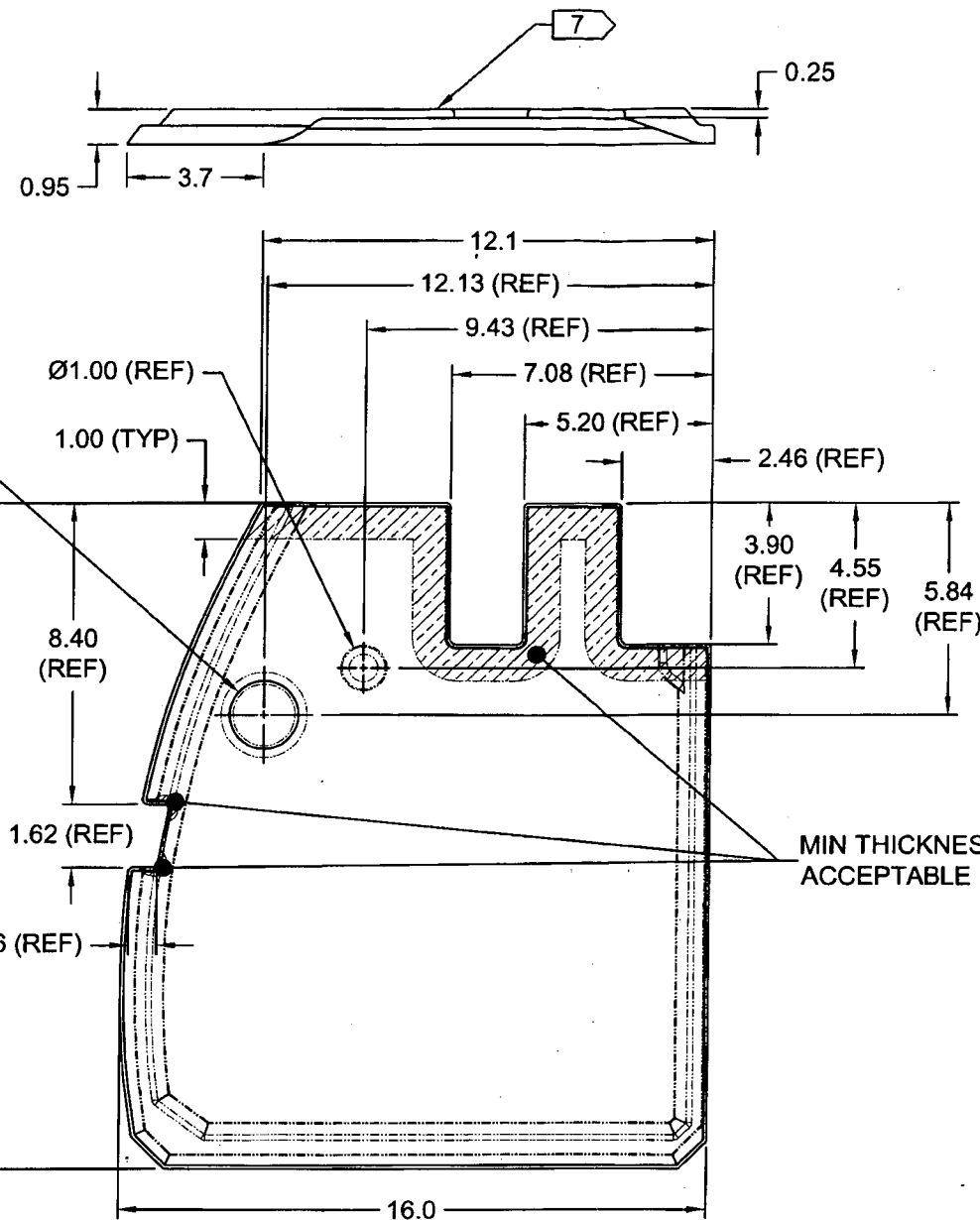
Measured by: BB Date: 08/06/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.35	✓			
15.8	+/-0.100	15.82	✓			
12.1	+/-0.100	12.1	✓			
0.95	+/-0.030	.95	✓			
0.25	+/-0.030	.258	✓			
0.070	Min	.76	✓			
0.050	Min	.69	✓			

Measured by: BB Date: 08/06/03
Audited by: BB Date: 08/06/03
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	



D3280-1 FLOOR PROTECTOR

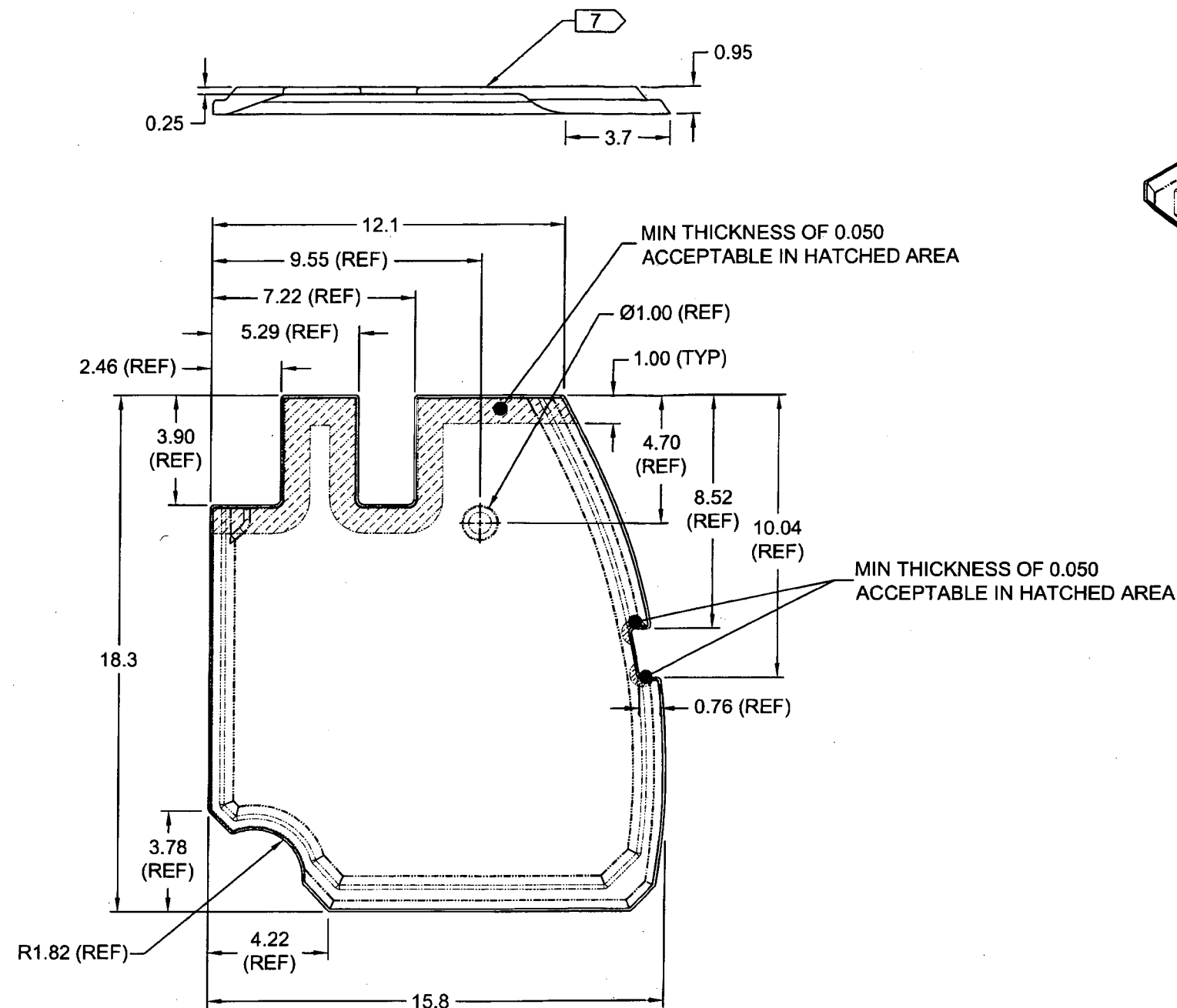
D3280-1 NOTES:

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.94 lb

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38576

RELEASED
08.04.11

D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	92	DRAWING NO.	REV. D
MFG. APPR.	92	D3280	SHEET 1 OF 2
APPROVED	92	TITLE	SCALE
DE APPR.	92	FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3280-3 FLOOR PROTECTOR

D3280-3 NOTES:

- 1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.88 lb

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39596

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. D
MFG. APPR.	92	D3280	SHEET 2 OF 2
APPROVED	92	TITLE	SCALE
DE APPR.	92	FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			